

Work Order ID 109648

Friday, November 22, 2013 1:58:48 PM

D4134-3

B109648

109648

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Item ID: D4134-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gasket

Start Date: 11/22/2013 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 11/22/2013 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: *ME*

Date: 13-11-22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4134 | B | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | FLOW WATER JET | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D4134 | | | | | | | | |
| <i>no 60 . 003</i> | Dwg Rev: <i>B</i> | | | | | | | | |
| | Prog Rev: <i>B</i> | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
27
9-89

13/11/25

2 0 Jm 13-11-23

2 0 Jm 13-11-23

2

Work Order ID 109648

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Friday, November 22, 2013 1:58:48 PM

Item ID: D4134-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Gasket

Stop *NS2*

Start Date: 11/22/2013 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 11/22/2013 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: F10-001 0.00

130

Packaging

Memo

0.00

Packaging

x2 d ll 13/11/27

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

13/11/27

13-11-25

Picklist Print

Friday, November 22, 2013 1:58:47 PM

Page 1

Work Order ID: 109648

Parent Item: D4134-3

Parent Item Name: Gasket

Start Date: 11/22/2013

Required Date: 11/22/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.25 new issue DD verf:EC
REV.B DD verf:EC

IPP Rev:B 10.11.22 AS PER DWG

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MNEO60S.063 NEOPRENE SHEET 0.063 | | Purchased | No | | | 100 | sf | 440.4400 | 1.0435 | 3 | | | |

Jm13-11-23

Location

Loc Qty

Loc Code

MAT052

440.44

M126546

440.44

126546

8 7 6 5 4 3 2 1

D

C

B

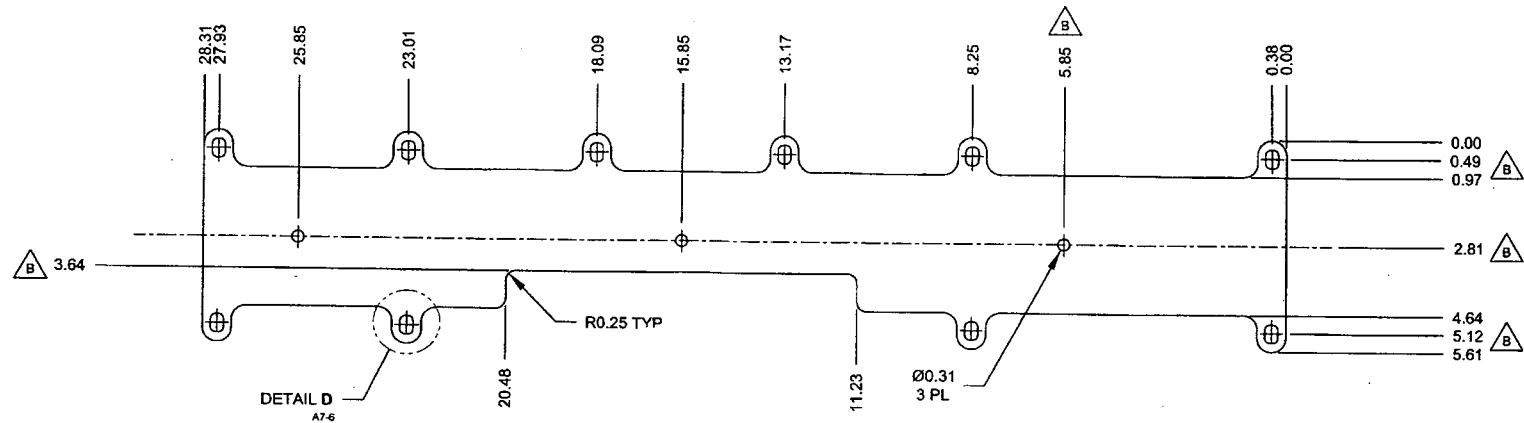
A

D

C

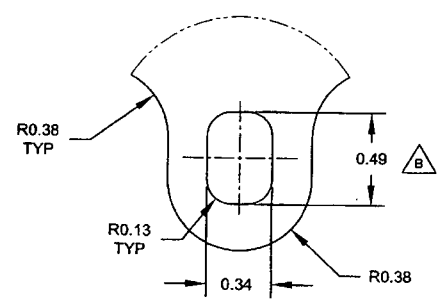
B

A



D4134-3 GASKET

#109648
ME
13-11-22



DETAIL D
SCALE 5X

RELEASED
2010-10-27

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
REF DART SPEC M-NEO60-S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.36 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | 9P | DART AEROSPACE USA, INC | |
| DRAWN | 9P | PORT HADLOCK, WA | |
| CHECKED | 9P | DRAWING NO. | REV. B |
| MFG. APPR. | 9P | D4134 | SHEET 6 OF 6 |
| APPROVED | 9P | TITLE | SCALE |
| DE APPR. | 9P | WEARPLATE, AFT | NTS |
| DATE | 10.09.15 | <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

8 7 6 5 4 3 2 1

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 109648 |
| Description: Gasket | | Part Number: | 04134-3 |
| Inspection Dwg: 04134 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.49" | +1-0 0.30 | 0.49" | ✓ | | U | Jkmo1 |
| 0.34" | " | 0.34" | ✓ | | U | |
| 0.49" | " | 0.49" | ✓ | | U | |
| 0.97" | " | 0.97" | ✓ | | U | |
| 2.81" | " | 2.81" | ✓ | | U | |
| 4.64" | " | 4.64" | ✓ | | U | |
| 5.12" | " | 5.12" | ✓ | | U | |
| 5.61" | " | 5.61" | ✓ | | U | |
| 3.64" | " | 3.64" | ✓ | | U | |
| 11.23" | " | 11.23" | ✓ | | U | Produced |
| 20.48" | " | 20.48" | ✓ | | T | Jkmo6 |
| 0.38" | " | 0.38" | ✓ | | U | |
| 5.85" | " | 5.85" | ✓ | | U | |
| Ø 0.31" | " | 0.31" | ✓ | | U | |
| 8.25" | " | 8.25" | ✓ | | U | |
| 13.17" | " | 13.17" | ✓ | | T | |
| 15.85" | " | 15.85" | ✓ | | T | |
| 18.09" | " | 18.09" | ✓ | | T | |
| 23.01" | " | 23.01" | ✓ | | T | |
| 25.85" | " | 25.85" | ✓ | | T | |
| 27.93" | " | 27.93" | ✓ | | T | |
| 28.31" | " | 28.31" | ✓ | | T | |
| 0.060" | +1-0 0.10 | 0.060" | ✓ | | U | |

| | | |
|------------------------|-------------------------|------------------------------|
| Measured by: JM | Audited by: 9-89 | Preliminary Approval: |
| Date: 13-11-23 | Date: 13/11/25 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

10.04.15